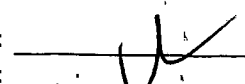
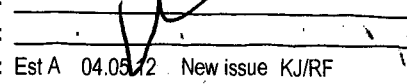













Date: Wednesday, 04/10/2006 2:21:56 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Job Number : 28839 Estimate Number : 10433 P.O. Number : N/A This Issue : 04/10/2006 S.O. No. : N/A Prsht Rev. : NC First Issue : N/A Type : PURCHASED PARTS Previous Run : 28839 Written By :  Checked & Approved By :  Comment : Est A 04.05.02 New issue KJ/RF Est Rev:B Now On Waterjet 06-08-14 JLM		Drawing Name : GASKET Part Number : D32555 Drawing Number : D3255 REV B Project Number : N/A Drawing Revision : B Material : N/A Due Date : 20/10/2006 Qty: 6 Um: Each	
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	D3255	Gasket	
 			
Comment: Qty.: 1.6182 Each(s)/Unit Total: 9.7089 Each(s) Gasket use D3255 .063" thick silicone coated fiberglass Batch: B28853 <i>ML 07 06 17</i>			
2.0	WATER JET	FLOW WATER JET	
 			
Comment: FLOW WATER JET 1-Cut as per.Dwg D3255 Dwg Rev: B Prog Rev: B 2-Deburr if necessary <i>SAD 07/06/19 6</i>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
 			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>SAD 07/06/19 6</i>			
4.0	QC8	SECOND CHECK	
 			
Comment: SECOND CHECK <i>En 02/06/20 (6)</i>			
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
 			
Comment: PACKAGING RESOURCE #1 Identify and Stock Location <i>5787</i> <i>LC 7/6/21 (6)</i>			

Date: Wednesday, 04/10/2006 2:21:56 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 28839

Part Number: D32555

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

2007/06/22

Job Completion



12 of 0622

Date: Tuesday, 10/3/2006 2:51:29 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GASKET
Job Number : 28839	
Estimate Number : 10433	
P.O. Number :	Part Number : D32555
This Issue : 10/3/2006 S.O. No. :	Drawing Number : D3255 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 28136	Material :
Written By :	Due Date : 10/25/2006 Qty: 6 Um: Each
Checked & Approved By : <u>06 10 03</u>	
Comment : Est A 04-05-12 New issue KJ/RF Est Rev:B Now On Waterjet 06-08-14 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D3255	Gasket
-----	-------	--------



Comment: Qty.: 1.6182 Each(s)/Unit Total : 9.7089 Each(s)
 Gasket use D3255
 .063" thick silicone coated fiberglass
 Batch: _____

2.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

3.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location _____

5.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

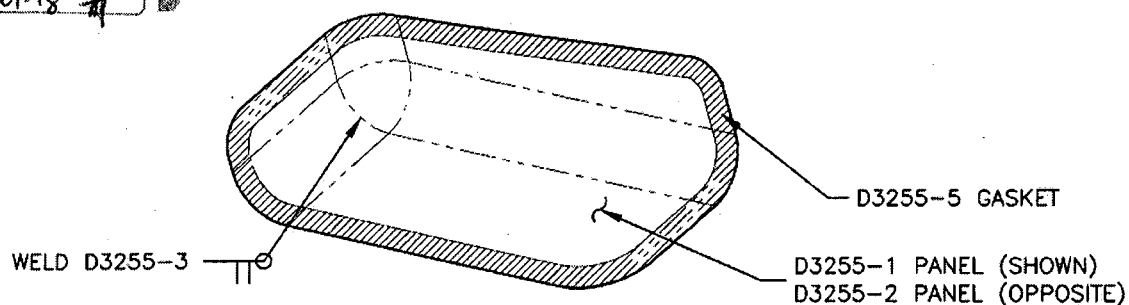
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

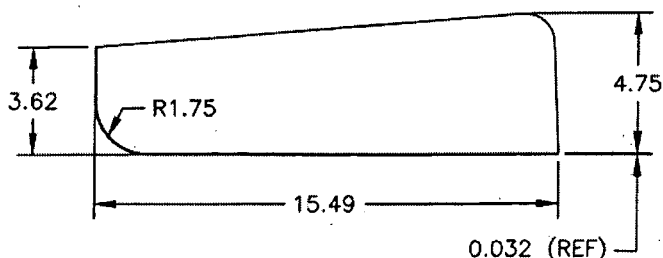
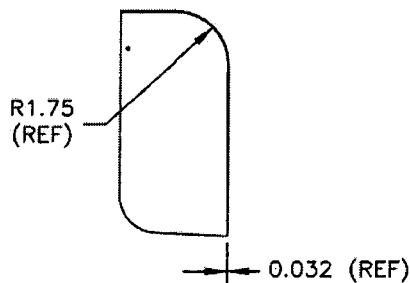
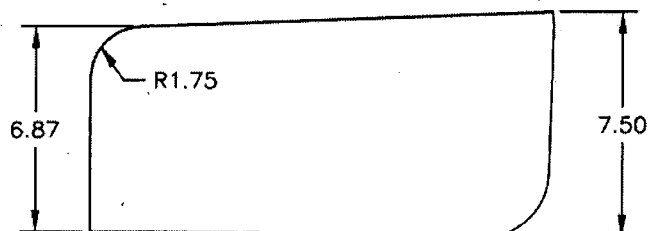


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ip	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098	

RELEASED
05-01-18 #



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

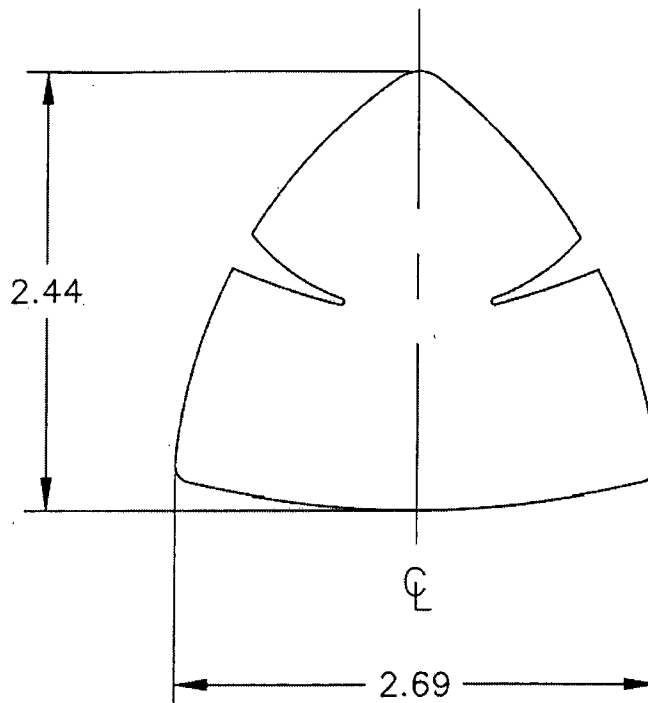
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CHECKED 4P	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED
05-01-08 #

D3255-3 CAP
FORM TO FIT D3155-1/-2

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

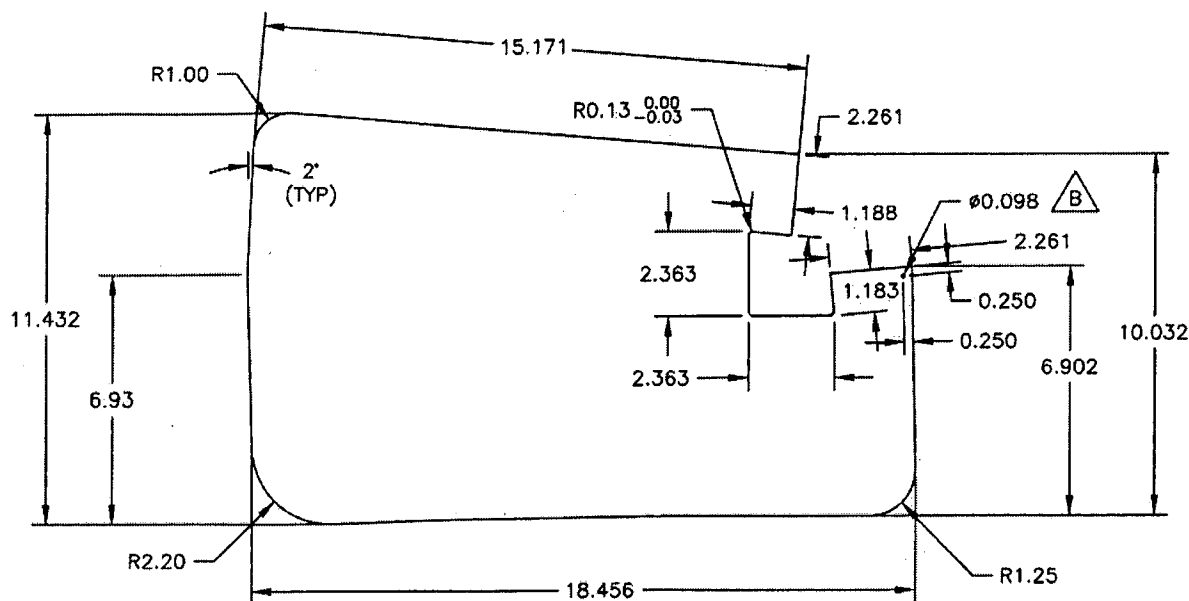
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CHECKED UP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05-01-18**D3255-1/-2 FLAT PATTERN****D3255-1/-2 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

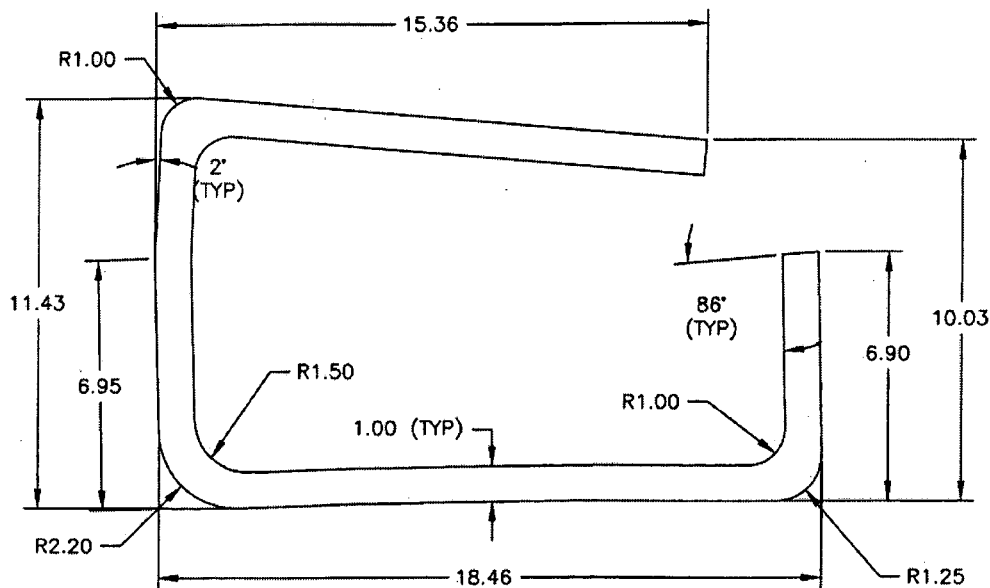
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DESIGN TJ	DRAWN BY TJ	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LP	APPROVED TJ	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05.01.18 TJ**D3255-5 GASKET****D3255-5 NOTES:**

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE LTD		Work Order: 28839
Description: GASKET		Part Number: D32555
Inspection Dwg: D3255 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	1.00	± 0.030	0.980	✓		Vern	
B	18.46	± 0.030	18.440	✓		M-T	
C	11.43	± 0.030	11.44	✓		M-T	
D	15.36	± 0.030	15.375	✓		M-T	
E	6.90	± 0.030	6.91	✓		Vern	
F	0.063	± 0.010	0.066	✓		Vern	
G							
H							
I							
J							
K							
L							
M							
N							
O							
P							
Q							
R							
S							
T							
U							
V							
W							
X							
Y							

Measured by: SMO	Audited by: EA	Prototype Approval:	N/A
Date: 07/06/19	Date: 07/06/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	